

# Work Order ID 72904

Wednesday, August 17, 2011 2:48:50 PM



Page 1

Item ID: D4278-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, Fwd Cham

Start Date: 8/17/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: 

Date: 8-17-11

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4277

D

D4278

C

100

Weld per dwg A/R S.S. rod Batch: 117884 0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs and weld as per dwg

PL11-08.23

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

~~PL11-08.23~~

11.08.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72904

Wednesday, August 17, 2011 2:48:50 PM



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Item ID: D4278-045

Accept



Setup Start



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Stop



Item Name: Rib Assembly, Fwd Cham

Start Date: 8/17/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/24

(x2)

130

Identify as per dwg & Stock Location: B/C

0.00



Packaging

Memo

0.00

Packaging

\*\*\*STOCK IN BASKET CELL\*\*\*

(x2)

Pl 11-08-24

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/24

11-08-24 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 17, 2011 2:48:55 PM

Page 1

Work Order ID: 72904



Parent Item: D4278-045



Parent Item Name: Rib Assembly, Fwd Cham

Start Date: 8/17/2011



Required Date: 8/25/2011


Start Qty: 2.00


Required Qty: 2.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC  
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4277-11 		Manufactured	No			100	Each	0.0000	1	2			
Rib													
D4277-7 		Manufactured	No			100	Each	0.0000	1	2			
Rib													

 B72905 → (2) Pl 11.08.23

 B76906 → (2) Pl 11.08.28

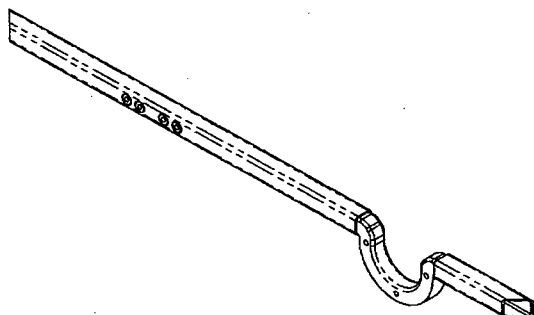
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

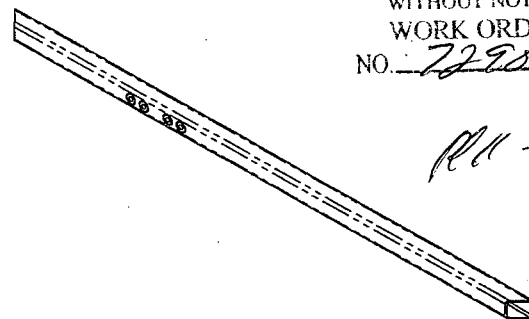
**NOTE:** Date & initial all entries



**D4278-041 UPPER RIB ASSY-HOOP** 



**D4278-045 RIB ASSY, FWD CHAM**



**D4278-047 UPPER RIB ASSY-STRAIGHT** 

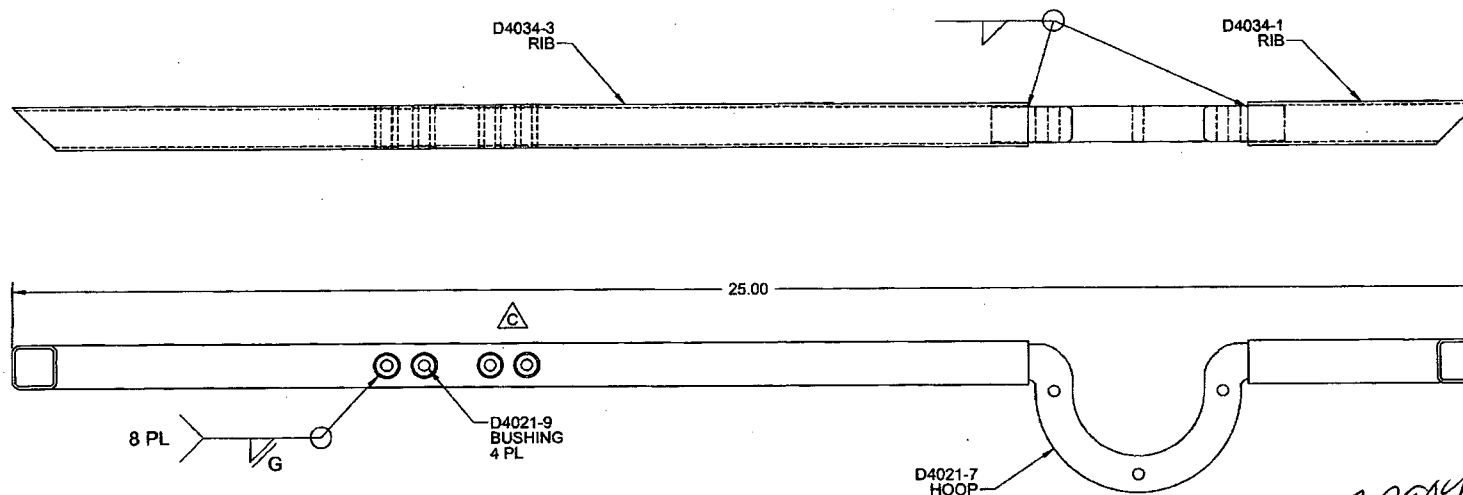
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72984

*RM-08-17*

**RELEASED**  
R 2011-01-18  
*MM*

C	ADDITIONAL HOLES ADDED IN D4278-041-047	SC	10.12.23
B	RMV -043 (OBSOLETE)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D4278</b>	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>RIB ASSEMBLY</b>	NTS
DATE	10.12.23	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-041	UPPER RIB ASSY-HOOP
1	1	D4021-7	HOOP
2	4	D4021-9	BUSHING
3	1	D4034-1	RIB
4	1	D4034-3	RIB



**D4278-041 UPPER RIB ASSY-HOOP**

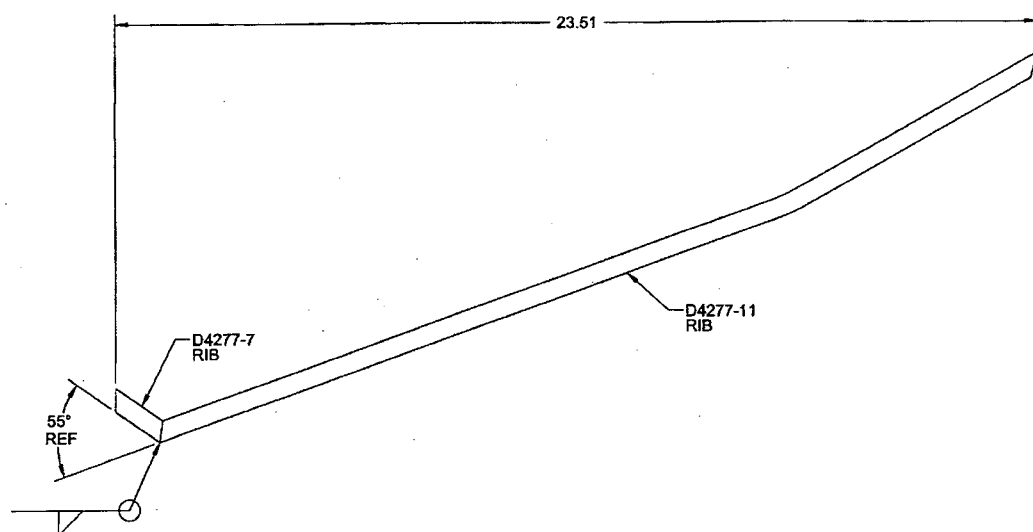
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	JRH	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 2 OF 4
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ITEM	QTY	PART NUMBER	DESCRIPTION
	-045		
		D4278-045	RIB ASSY, FWD CHAM
1	1	D4277-7	MID CORNER RIB, NOTCH
2	1	D4277-11	MID DIAG RIB



**D4278-045 RIB ASSY, FWD CHAM**

7204

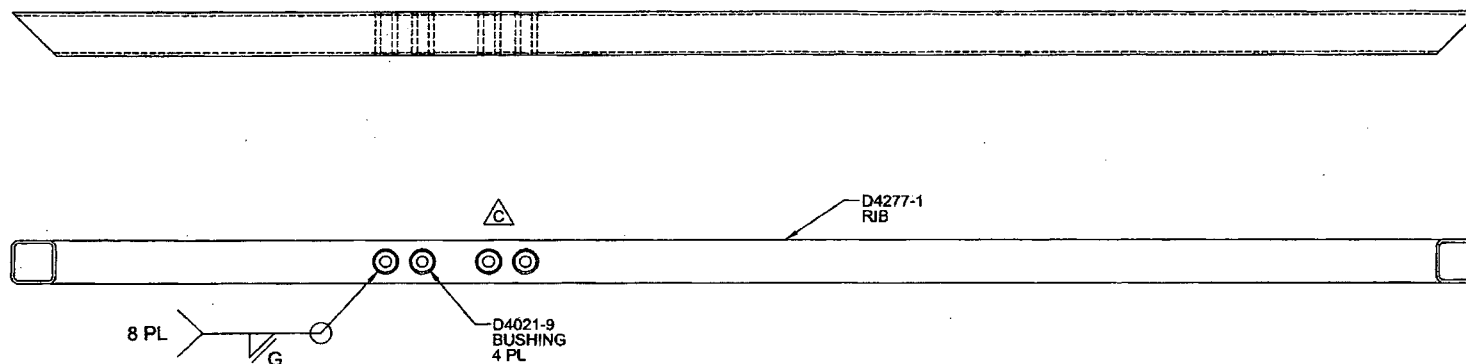
RELEASED  
2011-01-18  
JWH

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) WELD PER DART QSI 004.

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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ITEM	QTY	PART NUMBER	DESCRIPTION
	<del>4</del>	<del>D4278-047</del>	<del>UPPER RIB ASSY-STRAIGHT</del>
1	4	D4021-9	BUSHING
2	1	D4277-1	RIB



**D4278-047 UPPER RIB ASSY-STRAIGHT**

72909

RELEASED  
2011-01-18  
MJD

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.95 lbs
- 8) WELD PER DART QSI 004.

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4278</b>	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSEMBLY</b>	NTS
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